



Dart Aerospace Ltd.
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C3-19C

Job Sheet 181864



Part No: C3-19C

Job Qty: 1 ea

Part Name: C3 Cage



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/10/18

Job Tracking No:

Due Date: 9/21/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG C3-19C Rev 5 IPP Rev A 18.03.29 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		9/21/18	0.00	0.00	Start Up Large Fab-7		<i>EZ</i>
100	Large Fab	1 pcs		9/21/18	0.00	10.00	Large Fab 8		<i>EZ</i>
110	QC	1 pcs		9/21/18	0.00	0.00	QC9		<i>CPL</i>
120	QC	1 pcs		9/21/18	0.00	0.00	QC5		<i>CPL</i>
130	Powdercoat	1 pcs		9/21/18	0.00	0.50	Powdercoat6		<i>BL 18-12-20</i>
140	QC	1 pcs		9/21/18	0.00	0.00	QC3		<i>DAE</i> <i>DAE</i> <i>30</i>
150	Packaging	1 pcs		9/21/18	0.00	0.00	Packaging3-2		<i>M/A</i> <i>30</i> <i>9-89</i>
160	QC21-SA	1 Ea		9/21/18	0.00	0.00	QC21		<i>9-89</i> <i>9-89</i>

Part Op 100 - 1-MANUFACTURE AS PER DWG, TACK WELD FOR INSPECTION BY: *CPL* USE WELDING JIG C3-19C.
Descriptions: 2-Weld as per DWG. ***SEE NOTE 1, ALL HOLES MUST ALIGN***

130 - START TIME: *1:30* OVEN TEMPERATURE: *500°* FINISH TIME: *2:00*

DEC 21 2018

M 129223.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-A513-T-0.8750W0.120	A513 Seamless Alloy Steel Round Tubing 0.875"dia. x 8.7000 ft (8.7 ea)	90-Start up		
	0.120" Wall		Operation	<i>5089470</i>
C3-18-1	Lifting Plate	2 Ea (2 ea)	100-Large Fab	<i>5102085</i>
C3-18-5	Boss	2 Ea (2 ea)	100-Large Fab	<i>5116808</i>
C3-18-6	Bumper Bracket	1 Ea (1 ea)	100-Large Fab	<i>5058911</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-A513-T-0.8750W0.120	9	115	0
100-Large Fab			6	0



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Container No: S137281



Part: C3 - 19C

Job No: 181864

Serial No/Batch: S137281

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 12/12/18

ex 8/10/18 9:40 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				